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D4642-041
Job Sheet 187098



Part No: D4642-041

Job Qty: 1 ea

Part Name: Glareshield Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 1,2,5 IPP REV:A 12.06.12 NEW ISSUE DD VERF:EC IPP REV:B 13.02.11 PER DWG
REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1 pcs		1/31/19	0.00	0.35	Waterjet - Flow		52 18/12/10
110	QC	1 pcs		1/31/19	0.00	0.00	QC2		38 18/12/10
120	QC	1 pcs		1/31/19	0.00	0.00	QC8		38 9-88
130	Brake NC	1 pcs		1/31/19	0.00	0.82	Brake NC 2		38 9-88
140	QC	1 pcs		1/31/19	0.00	0.00	QC5		38 9-88
150	HandFinish	1 pcs		1/31/19	0.00	0.12	HandFinish1		38 9-88
160	QC	1 pcs		1/31/19	0.00	0.00	QC7		38 9-88
170	Powdercoat	1 pcs		1/31/19	0.00	0.00	Powdercoat4		38 9-88
180	QC	1 pcs		1/31/19	0.00	0.00	QC3		38 9-88
190	Small Fab	1 pcs		1/31/19	0.00	0.00	Small Fab		38 9-88
200	QC	1 pcs		1/31/19	0.00	0.00	QC5		38 9-88
250	Packaging	1 pcs		1/31/19	0.00	0.00	Packaging3		38 9-88
260	QC21-SA	1 Ea		1/31/19	0.00	0.00	QC21		38 9-88

Part Op 100 - 1-Cut D4642-1 as per dwg Prog rev: B Dwg rev: B 2-Deburr as required
Descriptions: 170 - START TIME: 2:25 OVEN TEMPERATURE: 320° FINISH TIME: 2:55 11/31/19
190 - 1- INSTALL PARTS AS PER DWG 2- BOND CHAFE GUARD WITH CONTACT CEMENT AS PER DWG
BATCH: 3- Make D4642-7 from D4730-015-020 **HOOK ONLY** TRIM TO FIT TAB ON -1/2 ON
INSTALLATION as per dwg note 9.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.032	6061-T6 Sheet 0.032"	1.3100 sf (1.31 ea)	100-Waterjet - Flow - 1	FM131173
43-13-1-24	Ejector Spring	2 pcs (2 ea)	190-Small Fab	FM124296-1
82-15-160-16	1/4 Turn Stud	2 pcs (2 ea)	190-Small Fab	FM124296-4
82-32-201-20	Retainer	2 pcs (2 ea)	190-Small Fab	FM124296-33
82-46-101-41	Wear Washer	2 pcs (2 ea)	190-Small Fab	FM124296
D4642-5	Chafe Guard	1 Ea (1 ea)	190-Small Fab	FM100831
D4730-015	Velcro Hook & Loop 1.5" Wide	.1580 (.158 ea)	190-Small Fab	FM134205

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.032	1	128	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		Container No: S136489 Part: D4642 - 041 Job No: 187098 Serial No/Batch: S136489 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 12/10/18			
Description Work Order Deviation							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Force ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐					
		Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____					

190-Small Fab

43-13-1-24
82-15-160-16
82-32-201-20
82-46-101-41
D4642-5
D4730-015

ME22 2016

2
2
2
2
1
0

10
10
10
10
4
0

0
0
0
0
0
0

Part Specifications

Specifications could not be found.

Plex 11/27/18 1:32 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	187098
Description: Gloreshield Assembly		Part Number:	04642-041
Inspection Dwg: 04642	Rev: B		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	SC	Checked by:	DAS 68	QC Inspector:	DAL 38
Date:	18/12/10	Date:	9-89	Date:	9-88 DEC 17 2018

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	